

ABSTRACT

A non-birefringent optical resin material is composed of a resin material and inorganic fine particle material birefringence sign of which are the same. A molten resin material, which contains an inorganic fine particle material, dispersed therein, of the same birefringence sign as that of the resin material, is caused to flow into a mold 4 through a gate 5. The molten material flows as to expand radially. Velocity vector of the flow has normal components P, R in addition to straight-ahead component S. Bonding chains of the resin material are generally orientated to the direction of velocity vector. In the vicinity of points A, B on an equiphase face 7, bonding chains of the resin material are generally orientated to lines extending from the exit of the gate 5 to point A and B, respectively. Flowing velocity has a gradient around each fine particle, causing the fine particle to be influenced by a moment and to tend to orientate so that the major axis of the particle is directed approximately parallel to equiphase faces 6 to 9 of the flow. On the whole material, this cancels birefringence.